

Date: Monday, 3/6/2006 1:56:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26082
 Estimate Number : 10390
 P.O. Number : NIA
 This Issue : 3/6/2006 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : MACHINED PARTS
 Previous Run : 25939
 Drawing Name : BAR
 Part Number : D3197041
 Drawing Number : D3197 REV A1
 Project Number : N/A
 Drawing Revision : A1
 Material : NIA
 Due Date : 3/24/2006 Qty: 30 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : J.F. 06.03.06
 Comment : Est Rev: A New Issue 05-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M7075T73R1000 7075-T73 Round Bar 1" OD



Comment: Qty.: 2.5410 f(s)/Unit Total: 76.2300 f(s)
 Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD
 (M7075T73R1.000)
 Identify for D3197-1
 Batch: M100286

J.F. 06/05/08 30

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 29.125" long

J.F. 06/05/08 30

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Face ends to lenght per dwg D3197
 2-Machine D3197-1 as per Folio FA340 and Dwg D3197
 3-Deburr

J.F. 06/05/08 30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/05/08 30

5.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
 Chamfer as per Dwg D3197

J.F. 06/05/09 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:56:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 26082

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/05/10 30

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HM 06/05/11

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-05-25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

D26905

Lanyard ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 2 D2690-5 Lanyard B 25475 (58)mx
B 25836 (2)mx.

11.0

D32421

Tag



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 2 D3242-1 TAG B 26086 (40)mx B 26415 (20)mx

12.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Pick:

Qty Part Number

Description Batch

180 12 AN960JD10 Washer 100743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/13/

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: BAR

Job Number: 26082

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DARS004

Pip Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W 2 DARS-004

Pip Pin

0 26707

034893200

14.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W 4 MS21042L3

Nut (or -3)

M100393

15.0

MS27039124

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W 4 MS27039-1-24 Screw

M19391-

28mx

M100274

32mx

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3197-041 as per Dwg D3197

M.F. 06-05-29

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

50137

06/05/30 (30)

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/31 30
06/05/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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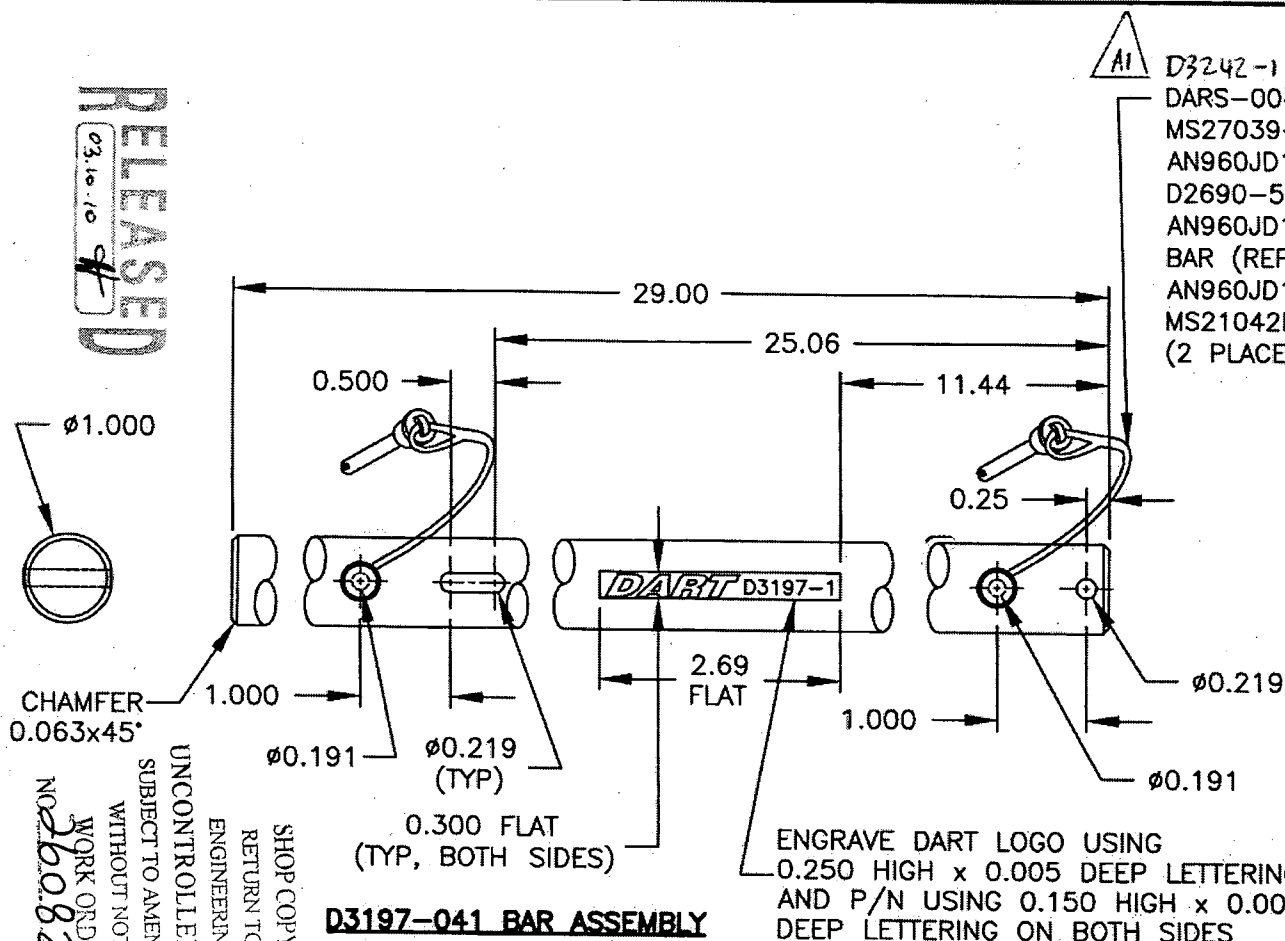
NOTE: Date & initial all entries

DART

REPRODUCED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		TITLE
03.07.01	03.07.01	BAR
A	NEW ISSUE	REV. A
A1	04.01.12	ADD D3242-1 TAG
		SHEET 1 OF 1
		SCALE
		1:1

D3242-1 TAG (1)
DARS-004 PIP PIN (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY.
IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN WITH A ϕ 0.188 DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

RELEASED
03.10.10

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 26082

